

### Product Description

**Bondchem M374** is a high strength two component structural acrylic adhesive, designed to bond a variety of substrates that require a totally clear, high viscosity adhesive. This ultra high strength is achieved by using a bespoke blend of advanced acrylic polymers which, when combined with our non-phthalate and non-MCL cure system, provide a fast bond speed with ultra high clarity.

### Advantages and Benefits

The traditional method of hand-mixing some alternative two- component clear systems, adds considerable time to the assembly process, as the mixed material is often left for any induced air to rise to the surface, and leave the mixture. Bondchem M374 eliminates this waste of production time, as no air is induced during mixing, due to the bespoke cartridge and mixer nozzle system, which also ensures that the user will attain a bubble-free bondline.

### Instructions For Use

1. Always consult MSDS before using **M374** for the first time.
2. Carry out surface preparation where required. \*
3. Remove cap, and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. Remove excess prior to cure using a suitable cleaner \*
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

*\*Contact your Bondchem representative for full information and usage instructions*

### Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Transparent
Appearance	Clear liquid
Viscosity Brookfield T Bar	175,000cps @ 25°C
Cure System	Exothermic
Open Time 10g Mass	2-3 Minutes @ 25°C
Handling Strength 10g Mass	5-7 Minutes @ 25°C

### Performance of Cured Material

Gap Fill	0.6 – 5mm
Temperature Range	-55°C to 120°C
ASTM D1002 Lapshear	Average Nmm <sup>2</sup>
Acrylic	4.05 (Substrate Failure)
Polycarbonate	7.36 (Substrate Failure)
PVC	5.01 (Substrate Failure)
ABS	5.44
PETg	7.15
Stainless Steel	16.5
Mild Steel	13.17
Aluminum	5.76

### Packaging

**Bondchem M374** is available in 25ml, 50ml and 400ml Cartridges to be used with dispensing gun.

### Storage & Shelflife

**Bondchem M374** should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly, this grade can offer a 12 month shelf life from manufacture.

### Health and Safety in Use

Bondchem M374 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.